



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3488-042

Job Sheet 171422



Part No: D3488-042

Job Qty: 6 ea

Part Name: Blade Fitting RH



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 2/1/18

Job Tracking No:

Due Date: 2/14/18

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG DSK 101 REV D, D3488 REV B IPP Rev:A New Issue 06-02-28 JLM IPP Rev:B As per Rev B 06-03-30
JLM IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/13/18	0.00	0.00	Start Up Machining-2		
100	Doosan	6 pcs		2/13/18	0.00	5.27	Doosan		18/02/09
110	QC	6 pcs		2/13/18	0.00	0.00	QC2 Machining-2		18/02/09
120	CNC Vertical Machining	6 pcs		2/13/18	0.11	4.11	HAAS1-3		SB 18/02/17
130	QC	6 pcs		2/13/18	0.00	0.00	QC2 Machining-2		SB 18/02/17
140	QC	6 pcs		2/13/18	0.00	0.00	QC8 Machining-2		18-03-01
150	HandFinish	6 pcs		2/13/18	0.00	0.18	HandFinish1		18-03-01
160	Powdercoat	6 pcs		2/14/18	0.00	0.21	Powdercoat1		18-03-01
170	QC	6 pcs		2/14/18	0.00	0.00	QC3		BE 18-03-07
180	HandFinish	6 pcs		2/14/18	0.00	0.00	HandFinish4		BE 18-03-07
190	QC	6 pcs		2/14/18	0.00	0.00	QC5		18-03-07
200	Packaging	6 pcs		2/14/18	0.00	0.00	Packaging3-1 FP001		BE 18-03-07
210	QC21-SA	6 Ea		2/14/18	0.00	0.00	QC21		21

Part Op 100 - 1-Turn as per Dwg DSK 101 & Folio FA625
Descriptions: 120 - 1-Machine as per Folio FA627 & Dwg D3488
160 - START TIME:
180 - Install Inserts as per Dwg D3488
200 - LOCATION : FP001

21 MAR 09 2018
9:50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003	Round Billet, Aluminum	6 Ea (1 ea)	90-Start up Operation	
ALS7-1032-225	Insert	24 Ea (4 ea)	180-HandFinish	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6103-003	6	6	0
180-HandFinish	ALS7-1032-225	24	78	0

DART
AEROSPACE
S040148

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Blade Fitting RH

PART NO: D3488 - 042

Original Serial #: S040148

Revision:

Operation:

Change No:

Start up Operation 02/07/18

Job No: 171422

DART AEROSPACE LTD	Work Order: 171422
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2	Part Number: D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2,153	✓		MIP-04	vern
Ø2.780	+/-0.005	2,780	✓			
Ø3.125	+/-0.010	3,125	✓			
Ø3.346	+/-0.010	3,347	✓			
0.125 x 45°	+/-0.010 x +/-0.1°	0,125 x 45°	✓			
8.000	+0.030/-0.000	8,013	✓			
9.250	+/-0.010	9,250	✓			
0.188	+/-0.010	0,188	✓			
R0.032	+/-0.010	0,032	✓			
R0.062	+/-0.010	0,063	✓			
Ø0.297	+0.005/-0.001	0,300	✓			
Ø0.430	+/-0.010	0,430	✓			
0.100	+/-0.010	0,100	✓			
0.125	+/-0.010	0,128	✓			
2.620	+/-0.010	2,620	✓			
3.500	+/-0.010	3,500	✓			
1.005	+/-0.010	1,005	✓			
Ø0.484	+0.005/-0.001	0,486	✓			
1.180	+/-0.010	1,179	✓			
3.150	+/-0.010	3,150	✓			
3.070	+/-0.010	3,062	✓			
R0.063	+/-0.010	0,063	✓			

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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	.508	✓		P.G.	
0.750	+/-0.010	.749	✓		Vern	SBL 01
1.500	+/-0.010	1.498	✓		11	
11.18	+/-0.030	11.180	✓		H.G.	
R0.062	+/-0.010	.062	✓		R.G.	
0.125	+/-0.010	.125	✓		Vern.	SBL-01
0.590	+/-0.010	.590	✓		H.G.	
0.793	+/-0.010	.793	✓		Vern.	SBL-01
1.351	+/-0.010	1.352	✓		H.G.	
1.317	+/-0.010	1.317	✓		Vern.	SBL-01
1.802	+/-0.010	1.802	✓		H.G.	

Measured by: SBL	Audited by: mgm	Prototype Approval:	N/A
Date: 18/02/17	Date: 18/03/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-042	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	